

Split

Dart Aerospace Ltd.

Date: Thursday, 6/28/2007 9:50:57 AM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	WEARPAD
Job Number :	33243 -1	Part Number :	D35641
Estimate Number :	12781	Drawing Number :	D3564 UNDER REVIEW
P.O. Number :	N/A	Project Number :	N/A
Issue :	6/28/2007 S.O. No. : N/A	Drawing Revision :	A C 02, 03, 12
Next Rev. :	NC	Material :	N/A
First Issue :	6/28/2007 Type : SMALL /MED FAB	Due Date :	7/10/2007 Qty: 20 Um: Each
Previous Run :	31417		
Written By :	[Signature]		
Checked & Approved By :	[Signature]		
Comment :	Est Rev: A New Issue 07-03-08 ec		

Additional Products

Job Number



Part #

Machine Or Operation:

Description :

M304S16GA

304316 063 Sheet



Comment Qty: 0.9177 sf(s)/Unit Total 18.3540 sf(s)

M304S16GA Stainless steel sheet 0.063" thick

Batch: M103961

B 07-07-18

20

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3564 ***** (D3564-1F)*****

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

B 07-07-18

(P10) ->

20

OC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

B 07-07-18

20

OC8

SECOND CHECK



Comment: SECOND CHECK

In 07/07/19

(420)

canted

20

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Deburr if necessary

Form on Brake as per Dwg D3564 using Jigs DT 5155 and DT 8179

SAD

Form Joggles (2) as per Dwg D3564 on brake using Jig DT

SAD 07/07/19

20

WORK ORDER CHANGES

W/O:	DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/07/19	12	Part SLAP distance from hole to outside LAB is too small 0.213" instead of 0.265" (0.052")		Scrap and Replace. Remind Employee to be more careful when making mat. on the water set. Bb 101 873	07/07/19	En		En
07/07/19	10	Part moved during water set.						
		Part moved during water set.						

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 33243

Part Number: D35641

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

Er 07/07/20 (420) *caution*

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description
A/R 2059B Hardcoat

Batch

H105358

28 07/07/25 (29)

Weld hardcoat as per Dwg D3437

8.0

QC2

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-07-27 (9)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD 07-07-27 (9)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

ml 07 07 27 (9)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

21 07 07-28 (9)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location:

FD - 18

m.p 07/08/02

13.0

QC21

FINAL INSPECTION/W/O RELEASE



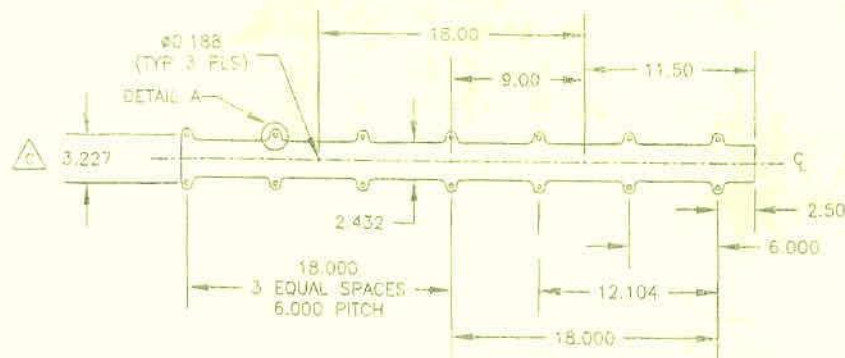
Comment: FINAL INSPECTION/W/O RELEASE

207/08/03 (9)

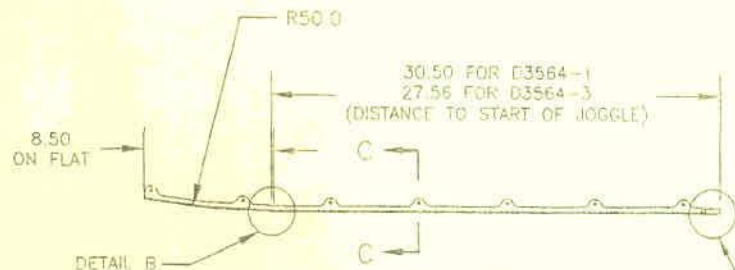
Completion



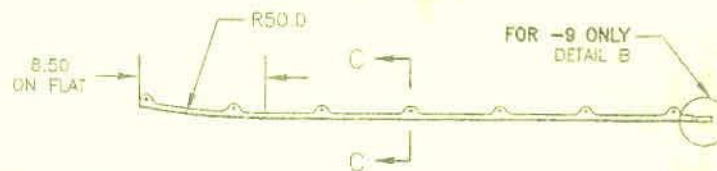
7/07-08-02



D3564-1F FLAT PATTERN



D3564-1/-3 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-9/-11 BENDING DETAIL
(MAKE FROM D3564-1F)

2059B HARDCOAT WELD
4.0 LONG
0.063 TO 0.125 HIGH
(TYP. 11 FLS.)
WELD AFTER BENDING AS
ILLUSTRATED PER DT8308



D3564-1/-3/-9/-11 WELDING DETAIL

RELEASED
07-16-28

D3564-1/-3/-5/-7/-9/-11/-13 WEARPLATE NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTLE (REF 4.5.6) PER DART QSI 005 4.5
- 3) WELD PER DART QSI 004
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 7) PART IS SYMMETRICAL ABOUT CENTERLINE

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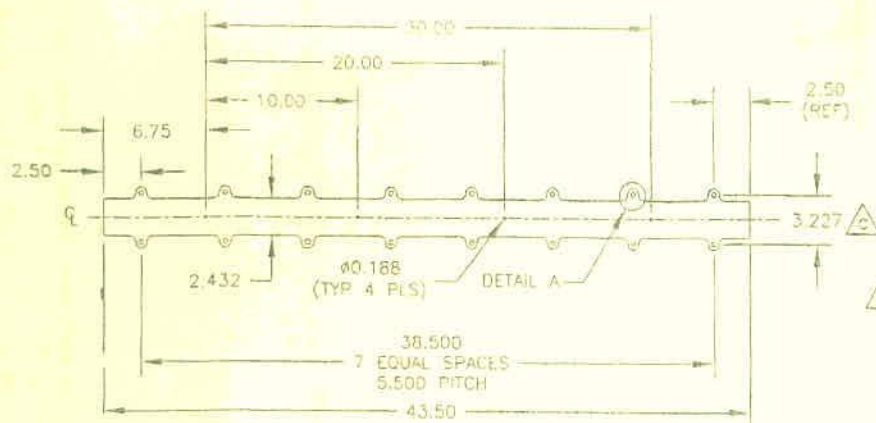
C	07.04.17	MOVE TAB OUTBOARD, DETAIL A
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.12.18	NEW ISSUE
DESIGN	DRN BY	DART AEROSPACE LTD.
CHECKED	APPROVED	DART AEROSPACE LTD.
DATE	TITLE	WEARSHOE
07.04.17		

REV. C

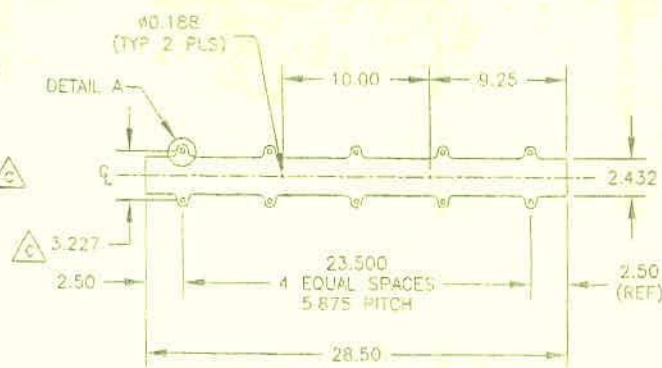
SHEET 1 OF 2

SCALE

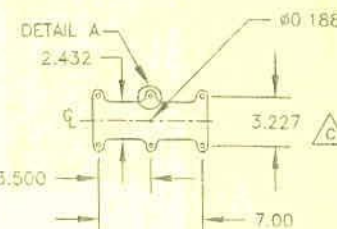
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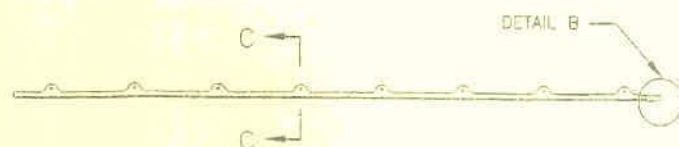
D3564-5F FLAT PATTERN



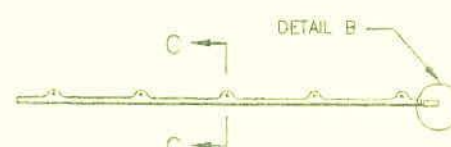
D3564-7F FLAT PATTERN



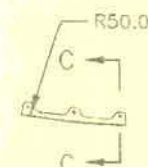
D3564-13F FLAT PATTERN



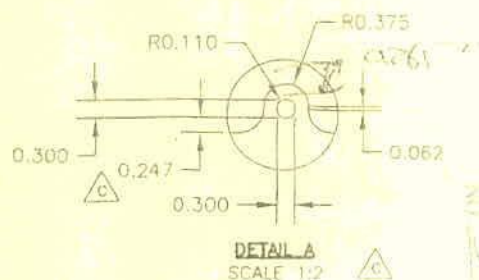
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



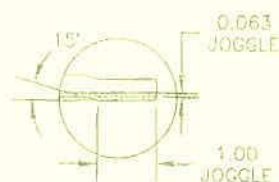
D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



DETAIL A
SCALE 1:2



DETAIL B
SCALE 1:2



SECTION C-C
SCALE 1:2

RELEASED
07.06.38

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		07/04/11	WILSON	WILSON	REV. C
				WILSON	SHEET 2 OF 2
				WILSON	SCALE
				WILSON	1:2

